

5/14

|                                                    |                     |         |
|----------------------------------------------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>                          | <b>Work Order:</b>  | 22762   |
| <b>Description:</b> Console Side RH (206 Hi-Slope) | <b>Part Number:</b> | D2602-2 |
| <b>Note: Issue with Part Number D2602-1</b>        |                     |         |
| <b>Dwg:</b> D2602 Rev. A1                          | <b>Qty:</b>         | 20      |
| Page 1 of 1                                        |                     |         |

| Step | Location | Procedure                                                                                                   | By  | Date     | Qty |
|------|----------|-------------------------------------------------------------------------------------------------------------|-----|----------|-----|
| 1    | DC       | Issue Traveler<br><b>Note: To be made in multiples of 10</b>                                                | EP  | 05.03.17 | 20  |
| 2    | MV       | Cut Blank per template DT8243<br>Material: 2024-T3 (QQ-A-250/4) 0.040" thick<br>(M2024T3S.040) Batch M16302 | EP  | 05/04/05 | 20  |
| 3    | MV       | Machine as per Folio FA145 and Dwg D2602<br><b>Stack of 10</b><br><b>Identify as D2602-2</b>                | EP  | 05/04/06 | 20  |
| 4    | QC2      | Inspect parts as they come off the CNC machine                                                              | EP  | 05/04/06 | 20  |
| 5    | QC8      | Second check                                                                                                | EP  | 05.04.06 | 20  |
| 6    | GA       | Deburr                                                                                                      | EP  | 05/04/11 | 20  |
| 7    | GB       | Form as per Dwg D2602                                                                                       | EP  | 05/04/12 | 20  |
| 8    | QC5      | Inspect work to Step 7                                                                                      | EP  | 05.04.15 | 20  |
| 9    | FP       | Acid etch and Alodine as per QSI 005 4.1.                                                                   | ML  | 05-04-15 | 20  |
| 10   | QC3      | Inspect work to Step 9                                                                                      | ML  | 05-04-15 | 20  |
| 11   | ST       | Identify and Stock                                                                                          | ML  | 05-04-15 | 20  |
| 12   | AC       | Cost / part 14.92                                                                                           | Soe | 05.04.19 | 20  |
| 13   | DC       | Close W/O 14.71<br>Inspect Level 21                                                                         | EP  | 05.04.26 | 20  |

| Rev | Date     | Change                        | Revised By | Approved |
|-----|----------|-------------------------------|------------|----------|
| A   | 96.07.27 | New Issue                     |            |          |
| B   | 98.05.08 | Added drawing revision        | KB         |          |
| C   | 98.11.25 | Added Inspection Levels       | DM         |          |
| D   | 02.06.04 | Added Alodine finish TSR 1290 | NG         |          |
| E   | 04.02.25 | Reformat                      | KJ/RF      |          |

RELEASED

04.05.06

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: 22762 |      | WORK ORDER NON-CONFORMANCE (NCR)                               |                             |                                                                                                  |                |                           |                              |                          |
|------------|------|----------------------------------------------------------------|-----------------------------|--------------------------------------------------------------------------------------------------|----------------|---------------------------|------------------------------|--------------------------|
| DATE       | STEP | Description of NC<br>Section A                                 | Corrective Action Section B |                                                                                                  |                | Verification<br>Section C | Approval<br>Design Mgr       | Approval<br>QC Inspector |
|            |      |                                                                | Initial<br>Design Mgr       | Action Description<br>Design Mgr                                                                 | Sign &<br>Date |                           |                              |                          |
| 05/04/12   | 7    | Some parts .005 .010<br>have .03 to .04<br>more than tolerance | CP                          | when benching: pair up<br>similar parts & maintain<br>0.674" flange dimensions<br>REF: W/O 22761 | SB<br>05/04/12 | AS-04-26                  | CP<br>05.04.26<br>per QSI 42 | IB<br>05.04.26           |
|            |      |                                                                |                             |                                                                                                  |                |                           |                              |                          |
|            |      |                                                                |                             |                                                                                                  |                |                           |                              |                          |

Part No: D2602-2 PAR #: \_\_\_\_\_ Fault Category: Prod./Inp. machining NCR: Yes No DQA: 9 Date: 05/04/2012

NOTE: Date & initial all entries

QA: N/C Closed: KA

Date: 05.04.26

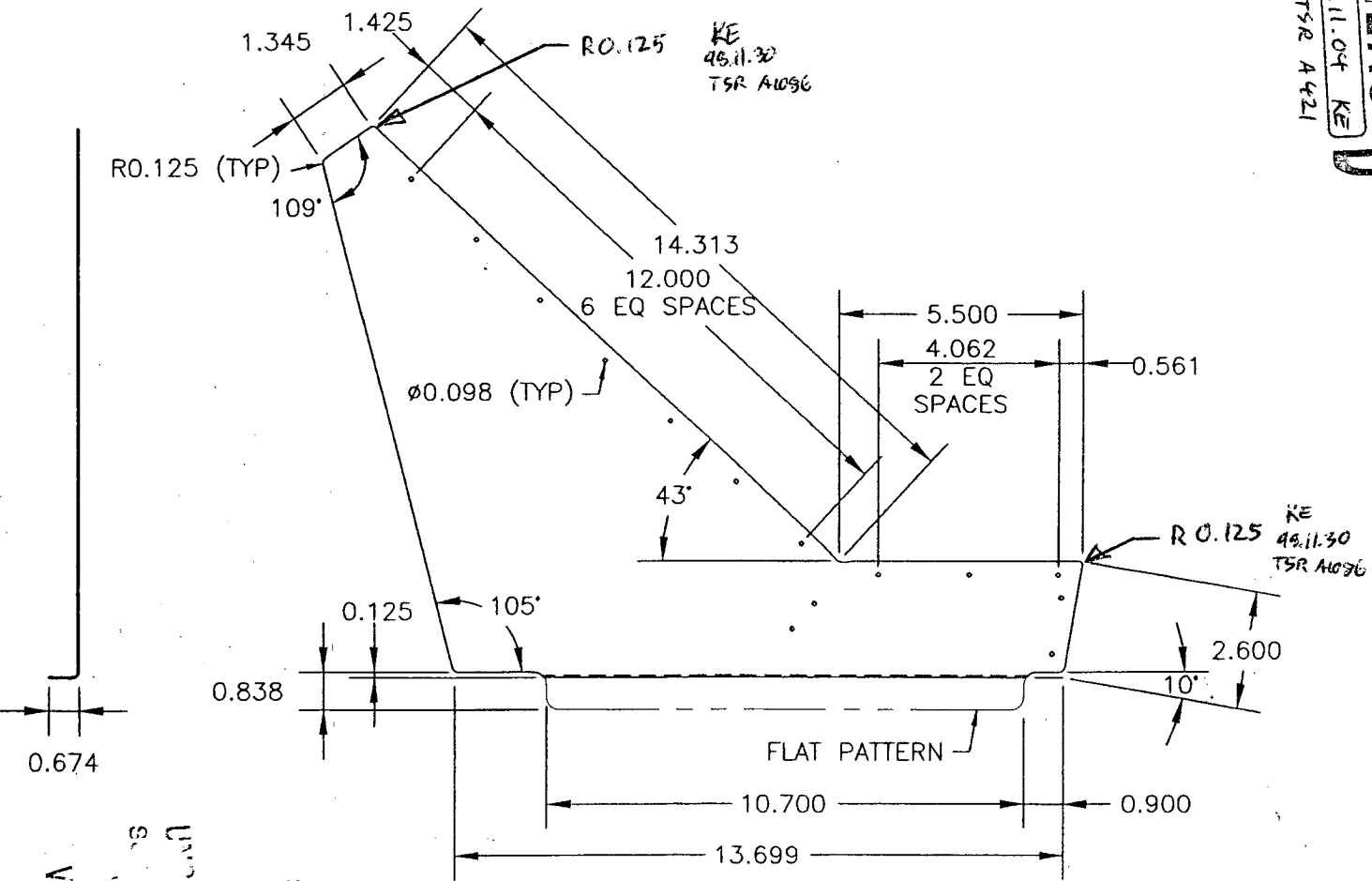


**DART**



**RELEASED**  
97.11.04 KE  
TSR A421

| DESIGN           | DRAWN BY              | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |
|------------------|-----------------------|--------------------------------------------------------------|
| CHECKED<br>KE    | APPROVED<br>Bw        | DRAWING NO.<br>D2602                                         |
| DATE<br>97.10.22 | TITLE<br>CONSOLE SIDE | REV. A<br>SHEET 1 OF 1                                       |
| A                | 97.10.22              | D2602 WAS D206-547-21/-22                                    |
| AI               | 02.06.04              | ADD FINISH                                                   |



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
PROFILE CONTROLLED BY FOLIO H2602  
BEND RADIUS 0.093  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
D2602-1 SHOWN  
D2602-2 OPPOSITE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNLESS OTHERWISE NOTED  
SHEET 1 OF 1

WORK ORDER  
NO. 22762

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Mar 17, 2005  
02:16 pm

Work Order No : 0022762  
Project Name : D2602-2  
Project For : WK514  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2602-2  
Description : Console Side Hi Slope  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 03-17-05  
Est Finish Date : 04-07-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

|                     | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours : | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost :  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours :  | 0.00      | 0.00   | 0.00   |        |         |
| Production Cost :   | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours :   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost :    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours :    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours :         | 0.00      | 0.00   | 0.00   |        |         |
| CNC :               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours :       | 0.00      | 0.00   | 0.00   |        |         |
| Misc. :             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Burden :            | 0.00      | 0.00   | 0.00   |        |         |
| Total Cost :        | 0.00      | 0.00   | 0.00   |        |         |
| Mark up :           | 0.000     | 0.000  |        |        |         |
| Selling Cost :      | 0.00      | 0.00   |        |        |         |

|                          | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00      | 0.00   |
| Profits/(Loss) :         | 0.00      | 0.00   |